



Date: Wednesday, 8/15/2007 3:18:27 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	: 33907		
Estimate Number	: 11001		
P.O. Number	: <i>N/A</i>	Part Number	: D26022
This Issue	: 8/15/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2602 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 31333	Material	: <i>N/A</i>
Written By	: <i>Just 07-02-15</i>	Due Date	: 8/31/2007 Qty: 20 Um: Each
Checked & Approved By	: <i>Just 07-02-15</i>		
Comment	: Est. E 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-1 Est Rev:E Now On Waterjet 07-03-22 JLM		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
			
<p>Comment: Qty.: 1.4146 sf(s)/Unit Total : 28.2912 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M105225</i></p> <p style="text-align: right;"><i>SAP 07/08/16</i></p>			
2.0	WATER JET	FLOW WATER JET	
			
<p>Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <i>A1</i> Prog Rev: <i>A1</i></p> <p>2-Deburr if necessary</p> <p style="text-align: right;"><i>SAP 07/08/16 20</i></p>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p style="text-align: right;"><i>SAP 07/08/16 20</i></p>			
4.0	QC8	SECOND CHECK	
			
<p>Comment: SECOND CHECK</p> <p style="text-align: right;"><i>En 07/08/20 420</i></p>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/28	6.0	20 parts were sent to Alviré before Bending. R.C. QC Inspector (E.D.) inspected for Deburring and Placement on the wrong Staff	<i>[Signature]</i>	have parts get Bent as per Dwg. D2602 - re-align and proceed @ sequence 7.0	SB 07/08/29 45 07/08/29	Ed 07/08/29	<i>[Signature]</i>	<i>[Signature]</i> 07/08/29

NOTE: Date & initial all entries

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Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 33907

Part Number: D26022

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr

Form as per Dwg D2602

100% 07/08/23 (20)

SB 07/08/29 (20)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HJ

07-08-22

(20)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57175

PC 7/8/31

(20)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

100% 07/08/31

Job Completion

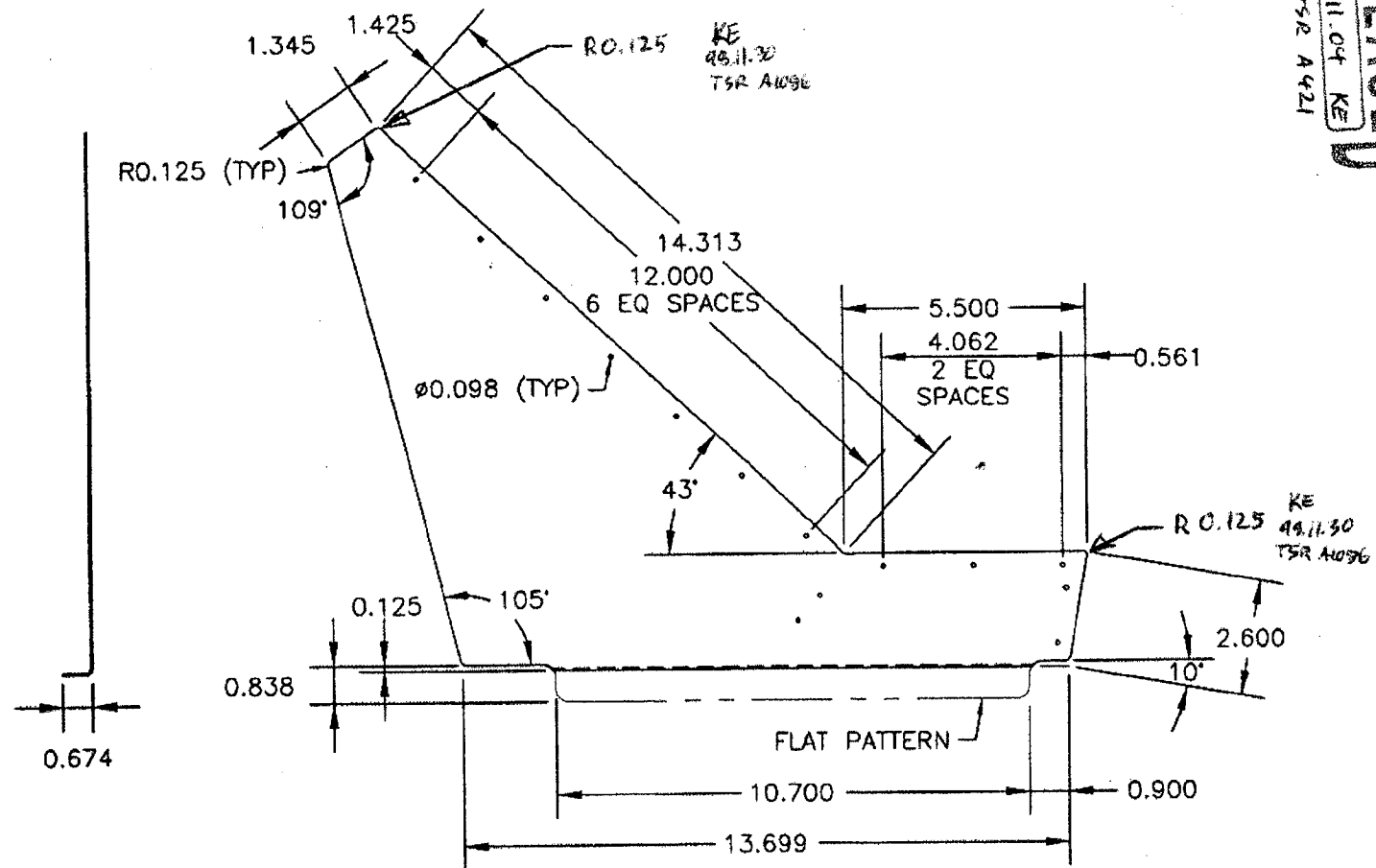


100% 07.08.31



RELEASED
97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED B.W.	DRAWING NO. D2602	REV. A SHEET 1 OF 1
DATE 97.10.22	DATE 97.10.22	TITLE CONSOLE SIDE	SCALE 1:4
A1	02.06.04	ADD FINISH	
		D2602 WAS D206-547-21/-22	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2602
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER PART Q51005 4.1 **AI**
D2602-1 SHOWN
D2602-2 OPPOSITE

